

Work Order ID 77606-1

77606

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December-13-11 3:35:30 PM

Item ID: D2893-1

Revision ID:

Item Name: 2.75 Support

Start Date: 13/12/2011 Start Qty: 20.00

Required Date: 23/01/2012 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: M.C.J

Date: 11/12/13 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2893	C

100
100
HAAS 1
HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo
1-Machine as per Folio FA081
2-Deburr

0.00

0.00

110
110
QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120
120
QC
Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

SPLIT - 1

6

20

20

SC/BA 12/1/13 6 -

SC/BA 12/1/13 6 -

RC 12.1.13 6 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77606

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Item ID: D2893-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 2.75 Support
 Start Date: 13/12/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 23/01/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

HandEXTube

Hand Finishing Crosstubes

Memo

Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.

0.00

M/1A2 12-01-09

140

140

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

6 12-01-09

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: *X-tube*

Memo

Assign

0.00

0.00

12-01-09

~~12-01-10~~

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/11/11 *[Signature]*

12-01-10
mf.

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 77606

77606

Parent Item: D2893-1

D2893-1

Parent Item Name: 2.75 Support

Start Date: 13/12/2011

Required Date: 23/01/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C02.11.26Reformat; Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

11.08.04 as per dwg rev.C DD verf:EC

IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	0.0000	0.5	10.52632			

DSK078

**

D2893-1 TURNING DETAIL

Location

Loc Qty

Loc Code

MAT

-10

MAT060 B 77191

10

10

B6

12/12/11

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DART AEROSPACE LTD		Work Order:	77606
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.992	2.992	2.996	2.995	2.995
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.130	.130	.130	.130	.130
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.145	.145	.145	.145	.145
AG	0.140	0.160		.145	.150	.150	.150	.150
AH	1.360	1.400		1.383	1.380	1.380	1.380	1.380
AI	0.040	0.060		.055	.055	.055	.055	.055
AJ	1.190	1.230		1.225	1.225	1.225	1.225	1.225
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39	DT 8699	✓	✓	✓	✓	✓
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: 36 / BA Date: 12/01/05

Audited by: 29 Date: 12.1.06

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

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DART AEROSPACE LTD		Work Order: 77606
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

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AG	0.140	0.160		.145				
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AI	0.040	0.060		.055				
AJ	1.190	1.230		1.225				
AK	0.010	0.020		.010				
AL	0.053	0.073		.063				
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AN	2.518	2.538		2.558				
AO	84.39	90.39	D2893	✓				
AP	0.261	0.266		.261				
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AS								
AT								
Accept/Reject								

Measured by: [Signature]	Date: 12/10/06
Audited by: [Signature]	Date: 12-1-06
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
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